

# Work Order ID 50899

July 24, 2009 9:53:06 AM



Page 1

Item ID: D3957-1  
Revision ID: A-PRELIM  
Item Name: Hinge, Door LH Upper

Accept

PRELIMINARY ISSUE

Setup Start

Stop

Start Date: 24/07/2009 Start Qty: 2.00

Required Date: 29/07/2009 Req'd Qty: 2.00

Reference: *09-07-24*

Cust Item ID:

Customer:



Run Start

Stop

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3957	A-PRELIM

100

0.00



Bandsaw

Memo

0.00

*mk 09/07/24*

*2*

Jeaspa Bandsaw

cut blank to 3.200" long

110

0.00



HAAS 1

Memo

0.00

*SF 09/07/24*

*2 0*

HAAS CNC vertical machine #1

1-Machine as per Folio FA838

FOLIO REV: AA

DWG REV: A

2-FINISH TAPPING TO FULL DEPTH BY HAND AS PER DWG

3-DEBURR AS PER dWG

# Work Order ID 50899

July 24, 2009 9:53:06 AM



Page 4

Item ID: D3957-1

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Hinge, Door LH Upper

Start Date: 24/07/2009 Start Qty: 2.00



Cust Item ID:

# Work Order ID 50899

July 24, 2009 9:53:06 AM



Page 2

Item ID: D3957-1

Accept



Setup Start



Revision ID: A-PRELIM

Stop



Item Name: Hinge, Door LH Upper

Start Date: 24/07/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 29/07/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

ENGINEERING  
APPROVAL

Jul 09.07.27  
09.07.27

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

W/A  
Jul 09.07.28

②

Status	Item ID	Rev	Name	Quantity Per UOM	Sort	Route Seq ID	Scrap %	Comments	Date Last Mod	Add Date
	M6061T6B0.750		6061-T6 Bar .750 x 4.00	0.266666 f	1	100	5 %		22/07/2009 1...	22/07/2009

M104 186 .266'      M101 283 .266'  
 CR 04/07/24

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50899
<b>Description:</b> <i>HINGE</i>		<b>Part Number:</b> D3957-1
<b>Inspection Dwg:</b> D3957	<b>Rev:</b> A	<b>Page 1 of 1</b>

PRELIMINARY

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

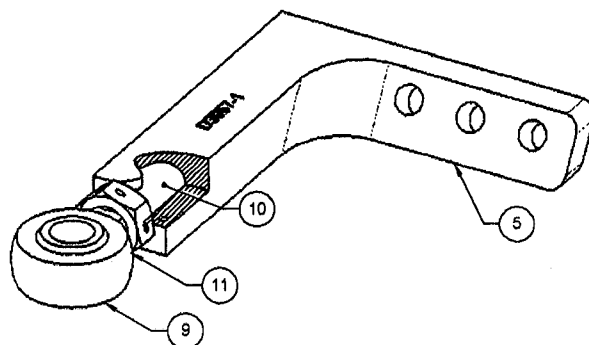
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1.25	Ref	1.257	✓			
.56	±.03	.561	✓			
.69	±.03	.686	✓			
.281	±.010	.285	✓			
.281	"	.276	✓			
3.00	±.03	2.998	✓			
.125	±.010	.123	✓			
.094	"	.090	✓			
.12	±.03	.220		✓		ENGRAVING TO HIGH
.25	±"	.252	✓			
.39	"	.386	✓			
.585	±.010	.585	✓			
1.170	"	1.171	✓			
.39	±.03	.386	✓			
Ø.257	+-.006 -.001	.259	✓			
Ø.063	+-.004 -.001	.064	✓			
Ø.391	±.006 ±.001	.394	✓			
R.50	±.03	.50	✓			
R.13	±.03	.13	✓			
120°	±1/2°	120°				

<b>Measured by:</b> <i>SS</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b> <i>NTA</i>
<b>Date:</b> 09/07/27	<b>Date:</b> 09/07/27	<b>Date:</b> 09/07/27

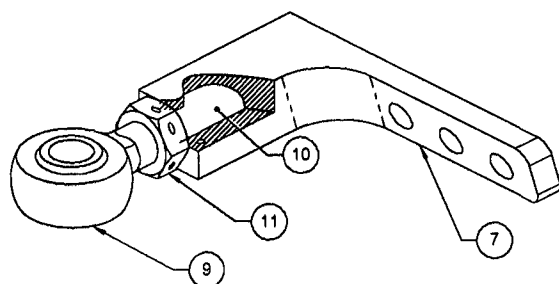
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



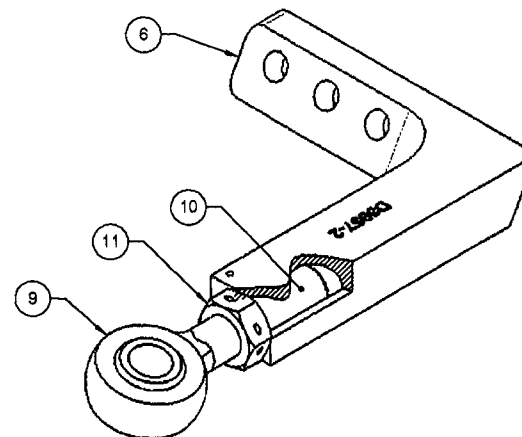
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2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3815-3	ROD END
10	1	1	1	1	MS124738	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



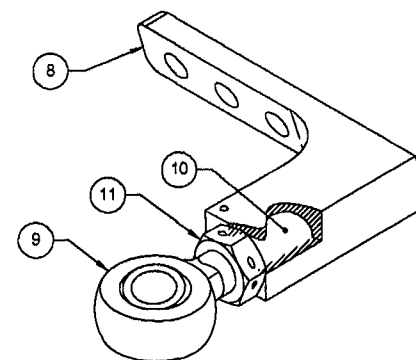
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**

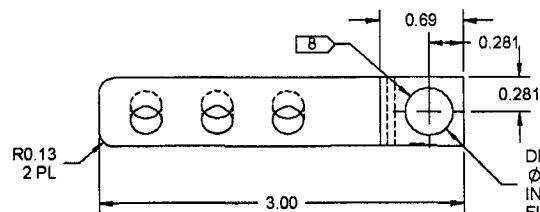


**D3957-044 HINGE ASSY, DOOR RH LOWER**

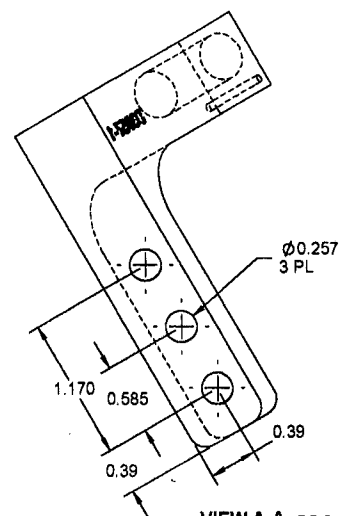
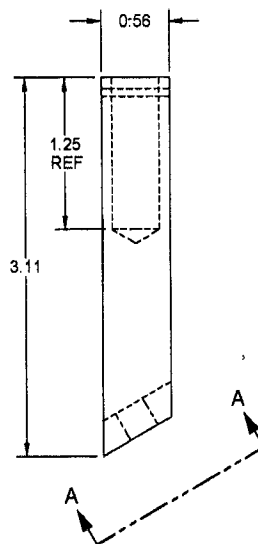
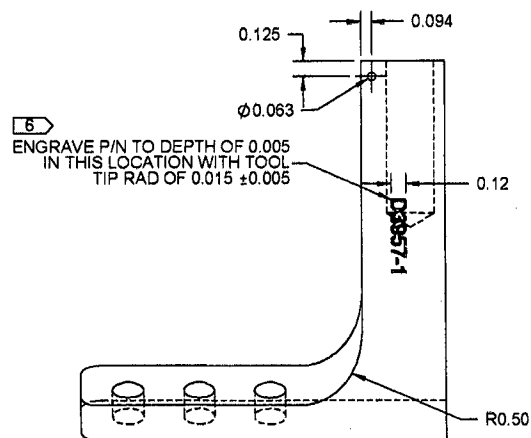
**PRELIMINARY ISSUE**

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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*w/o 50899*



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



VIEW A-A B5-2

120°

0.25

VIEW B-B C3-2

**D3957-1 HINGE, DOOR LH UPPER**

**PRELIMINARY ISSUE**

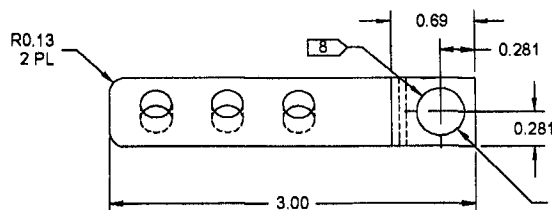
**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	AE	<b>DART AEROSPACE LTD</b>	
DRAWN	AE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	91	D3957	SHEET 2 OF 5
APPROVED	AO	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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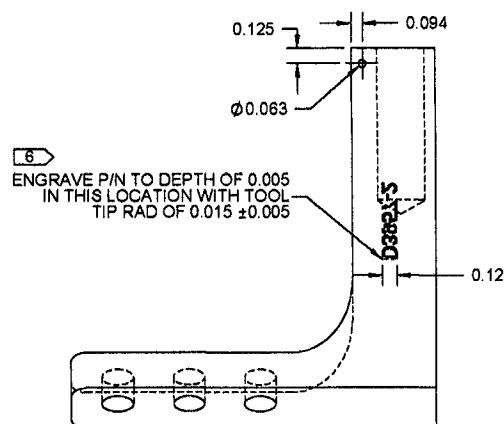
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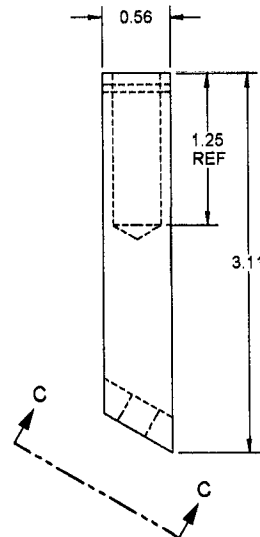


DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE

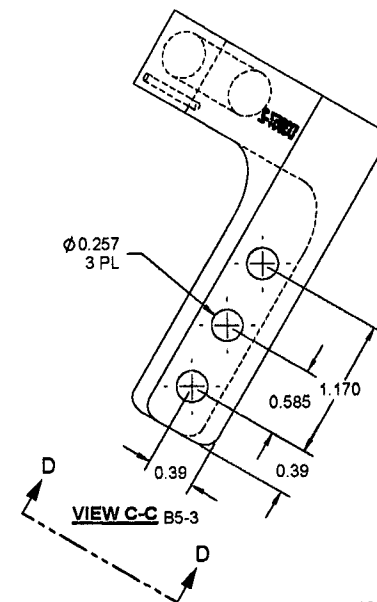
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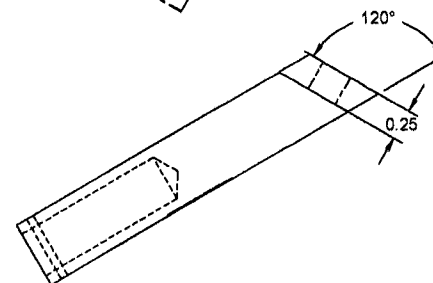
6  
 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF 0.015  $\pm 0.005$



**D3957-2 HINGE, DOOR RH UPPER**



**VIEW C-C B5-3**



**VIEW D-D C3-3**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.13 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**PRELIMINARY ISSUE**

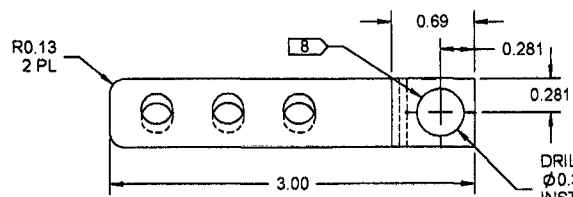
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	SA	D3957	SHEET 3 OF 5
APPROVED	NO	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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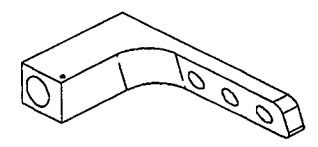
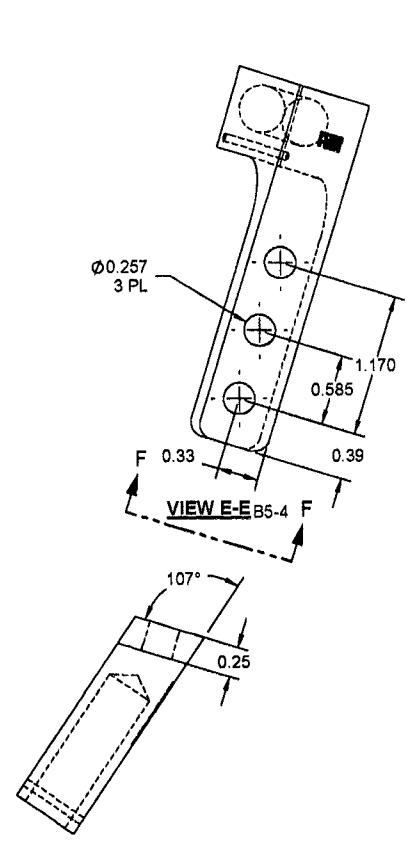
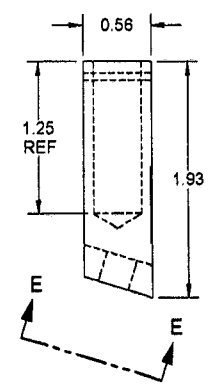
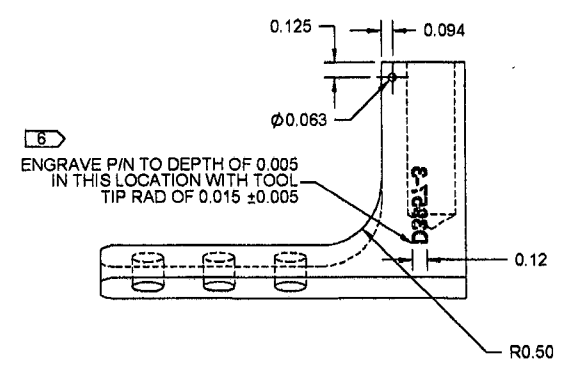
A

A





DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\phi 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



# **D3957-3 HINGE, DOOR LH LOWER**

**PRELIMINARY ISSUE**

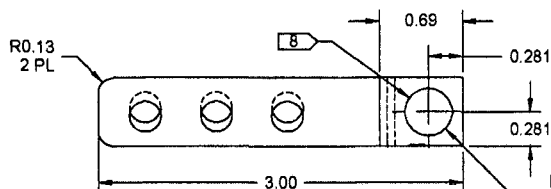
- NOTES:**
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 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
  - 7) WEIGHT: 0.09 lbs
  - 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN	AS	<b>DART AEROSPACE LTD</b>	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 4 OF 5
APPROVED	AD	TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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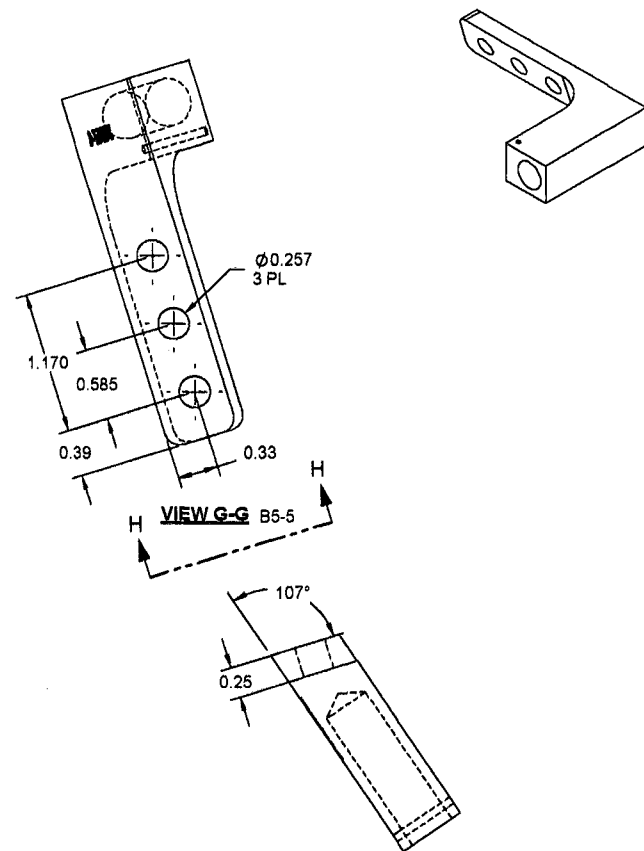
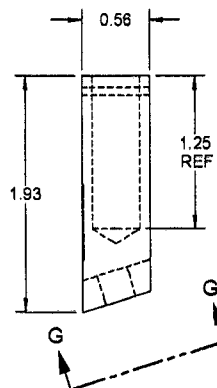
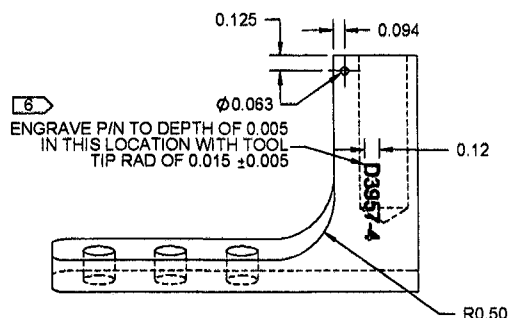
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D

D



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124738  
 FLUSH WITH SURFACE



VIEW G-G B5-5

VIEW H-H C3-5

**D3957-4 HINGE, DOOR RH LOWER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

**PRELIMINARY ISSUE**

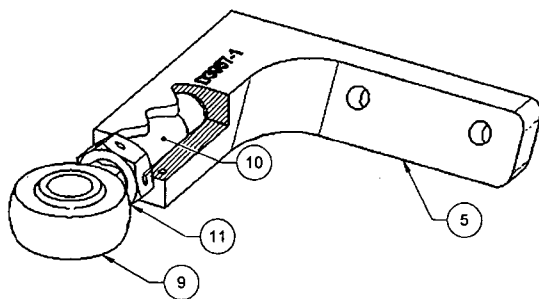
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CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3957	SHEET 5 OF 5
APPROVED	NO	TITLE	SCALE
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DATE	09.07.20	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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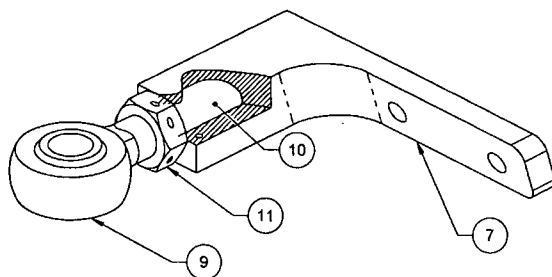
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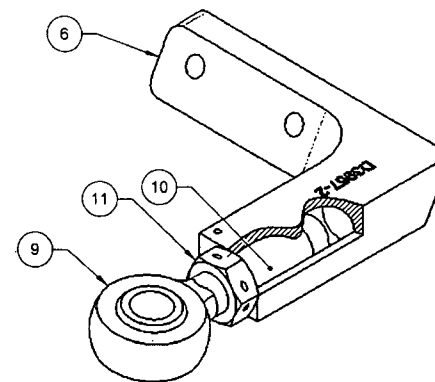
ITEM	QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X				D3957-041	HINGE ASSEMBLY, DOOR LH UPPER
2		X			D3957-042	HINGE ASSEMBLY, DOOR RH UPPER
3			X		D3957-043	HINGE ASSEMBLY, DOOR LH LOWER
4				X	D3957-044	HINGE ASSEMBLY, DOOR RH LOWER
5	1				D3957-1	HINGE, DOOR LH UPPER
6		1			D3957-2	HINGE, DOOR RH UPPER
7			1		D3957-3	HINGE, DOOR LH LOWER
8				1	D3957-4	HINGE, DOOR RH LOWER
9	1	1	1	1	D3518-3	ROD END
10	1	1	1	1	MS124818	HELICOIL, 3/8-24 UNF
11	1	1	1	1	NAS509-6	NUT



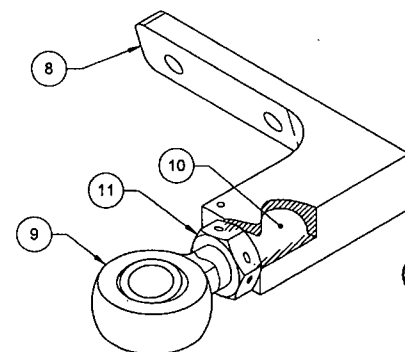
**D3957-041 HINGE ASSY, DOOR LH UPPER**



**D3957-043 HINGE ASSY, DOOR LH LOWER**



**D3957-042 HINGE ASSY, DOOR RH UPPER**



**D3957-044 HINGE ASSY, DOOR RH LOWER**

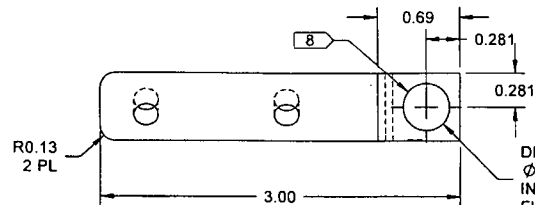
**RELEASED**  
2009-10-03  
JWP

A	NEW ISSUE	09.09.03
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DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	09.09.03	

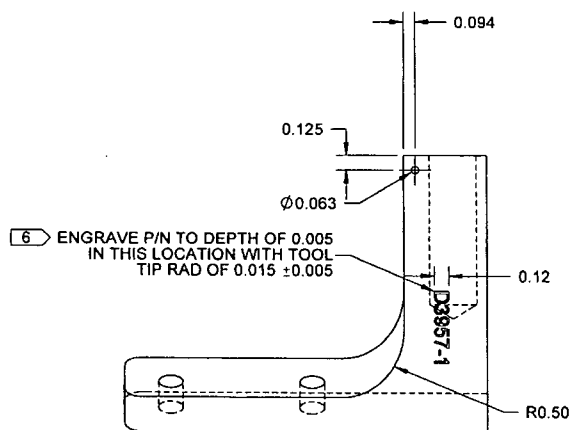
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D3957</b>	REV. A
TITLE <b>HINGE</b>	SHEET 1 OF 5
SCALE NTS	

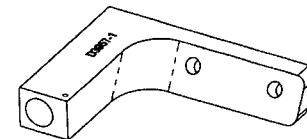
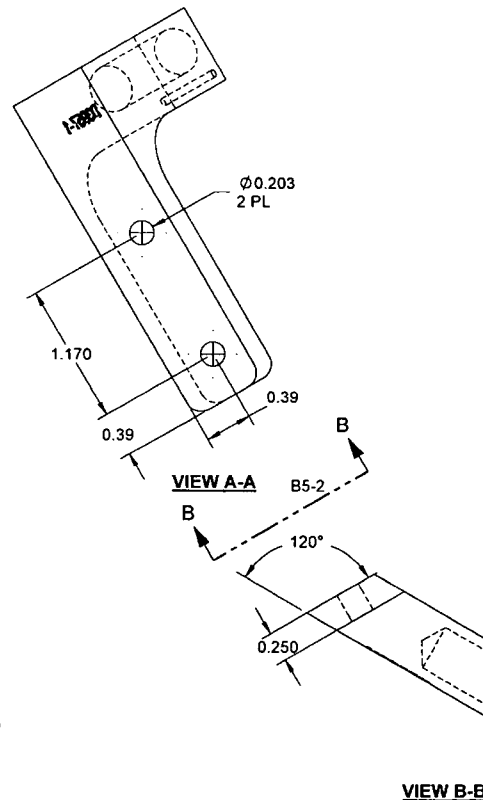
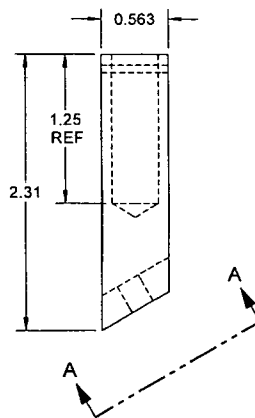
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DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF  $0.015 \pm 0.005$









50899

C3-2  
**RELEASED**  
 2009-10-08

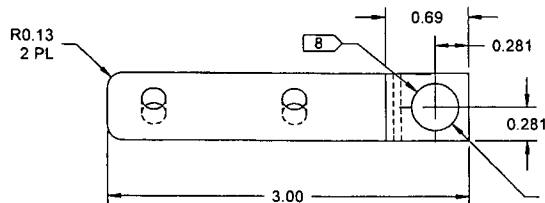
**D3957-1 HINGE, DOOR LH UPPER**

**NOTES:**

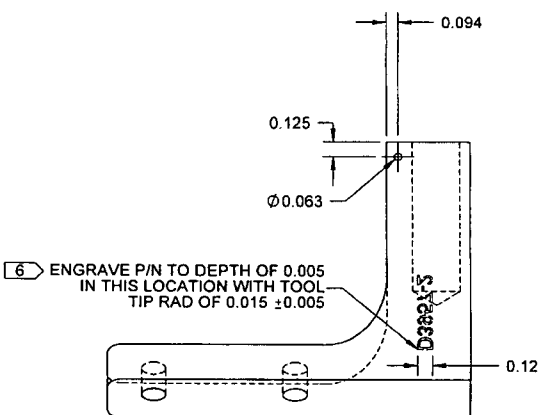
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.10 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

DESIGN		<b>DART AEROSPACE LTD</b>	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3957	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		HINGE	NTS
DATE	09.09.03	COPYRIGHT © 2003 BY DART AEROSPACE LTD	
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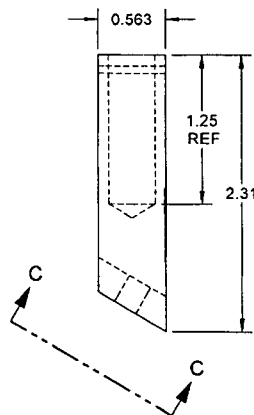
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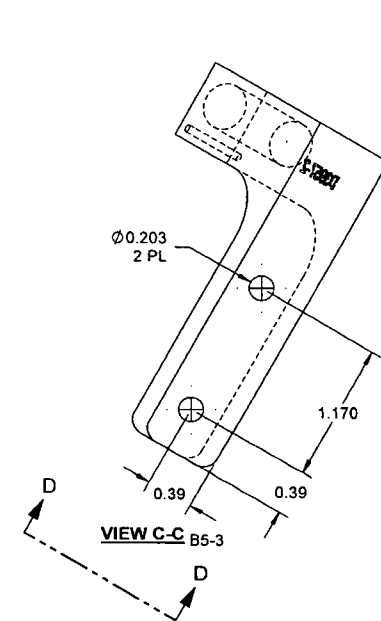
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



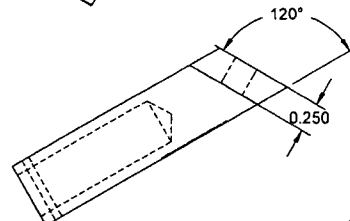
6 ENGRAVE P/N TO DEPTH OF 0.005  
 IN THIS LOCATION WITH TOOL  
 TIP RAD OF  $0.015 \pm 0.005$



**D3957-2 HINGE, DOOR RH UPPER**



**VIEW C-C**



**VIEW D-D**

C3-3

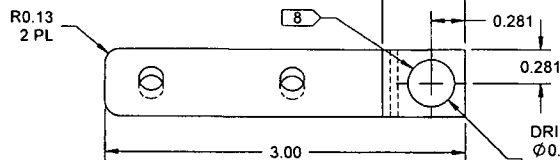
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**RELEASED**  
 2009-10-08

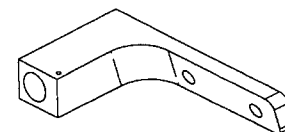
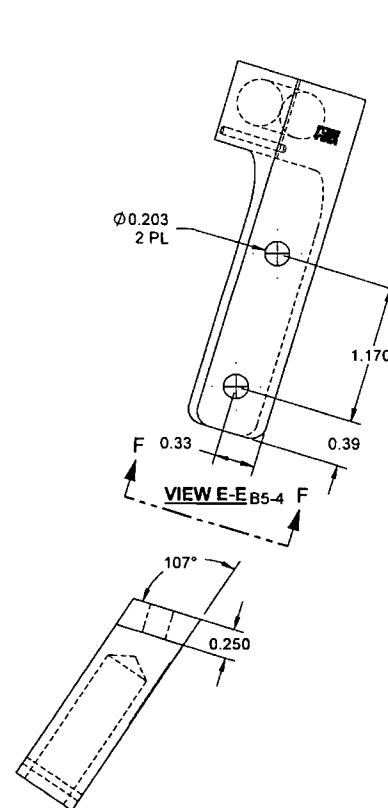
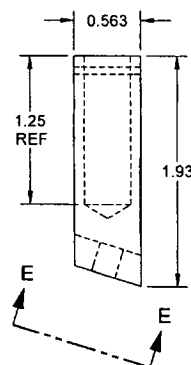
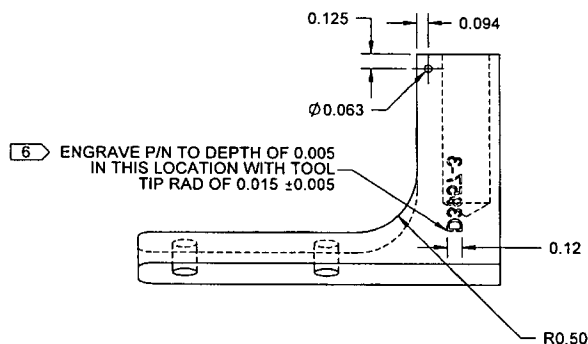
- NOTES:**
- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
  - 7) WEIGHT: 0.10 lbs
  - 8) MASK HOLE PRIOR TO POWDER COAT

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MFG. APPR.		D3957	SHEET 3 OF 5
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DE APPR.		HINGE	NTS
DATE	09.09.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS          NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT          WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1



DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391$  X 1.25 DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



# **D3957-3 HINGE, DOOR LH LOWER**

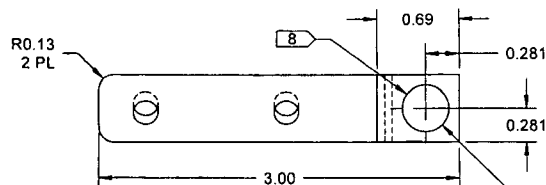
## **NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T651/T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

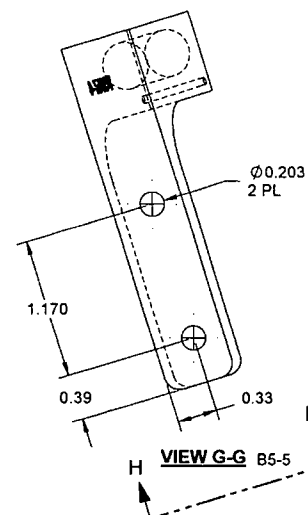
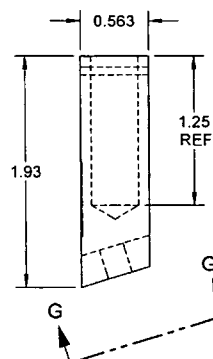
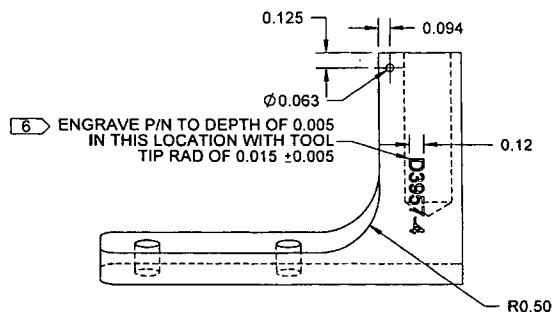
**RELEASED**  
 2009 -10- 08  
*map*

DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D3957</b>	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>HINGE</b>	NTS
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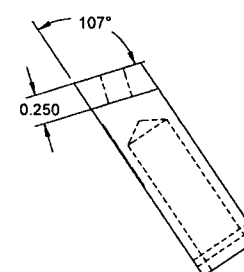
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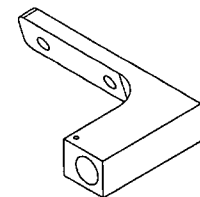
DRILL AND TAP FOR 3/8-24 HELICAL INSERT  
 $\varnothing 0.391 \times 1.25$  DP  
 INSTALL HELICOIL MS124818  
 FLUSH WITH SURFACE



VIEW G-G B5-5



VIEW H-H C3-5









**D3957-4 HINGE, DOOR RH LOWER**

**NOTES:**

- 1) MATERIAL: 6061-T6 (6061-T6510/T6511/T62) ALUMINUM BAR  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
 POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AS SHOWN
- 7) WEIGHT: 0.09 lbs
- 8) MASK HOLE PRIOR TO POWDER COAT

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 2009-10-08

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MFG. APPR.		<b>D3957</b>	SHEET 5 OF 5
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